

Date: Monday, 23/03/2009 3:02:53 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOUBLER
Job Number : 46667	
Estimate Number : 11645	
P.O. Number :	Part Number : D29921
This Issue : 23/03/2009 S.O. No. :	Drawing Number : D2992 UNDER REVIEW
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 38739	Material :
Written By :	Due Date : 30/03/2009 Qty: 6 Um: Each
Checked & Approved By :	
Comment : Est B 02.03.06 Added dwg Rev.B NG	
Est Rev:C 08-04-22 now on water jet DD verified by:	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S040	5052-H32 .040 Sheet
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Comment: Qty.: 0.0802 sf(s)/Unit Total : 0.4813 sf(s)

5052-H32 .040 Sheet

Material: 5052-H32 0.040" sheet

Batch: 104921 ★

ml 09 03 24

(6)

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D2992

Dwg Rev: U/R

Prog Rev: U/R

2-Deburr if necessary

ml 09 03 24 (6)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 09 03 24

(6)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

09 03 24 (6)

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

UMP/ FL

09 03 25 (X6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 23/03/2009 3:02:53 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 46667

Part Number: D29921

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



81



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-03-25

(16)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

send to Double

09/03/25

(6)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/25

Job Completion



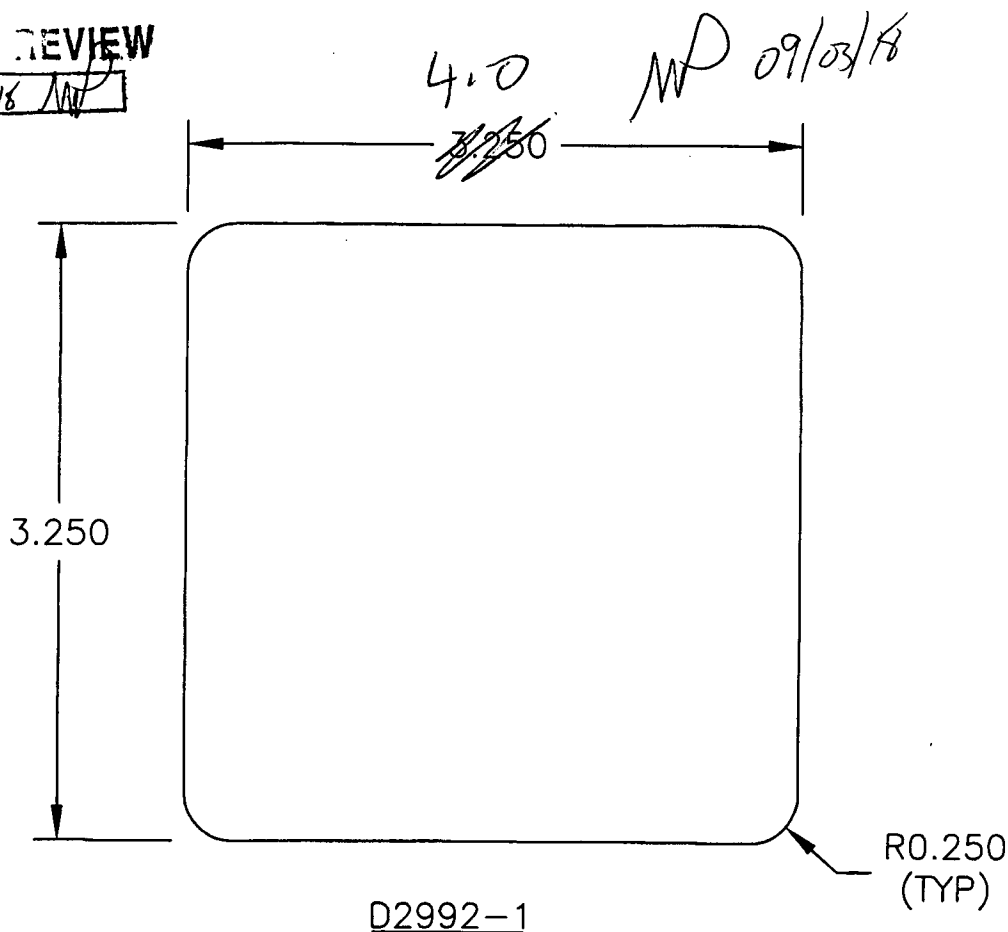
u 09.03.25



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>A</i>	APPROVED <i>A</i>	DRAWING NO. D2992	REV. A SHEET 1 OF 1
DATE 02.01.21		TITLE DOUBLER	SCALE 1:1
A	02.01.21	NEW ISSUE	

RELEASED
02.01.25 *A*

UNDER REVIEW
07/03/18 *MP*



NOTES:

MATERIAL: 5052-H32 (QQ-A-250/8) 0.040 THICK

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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